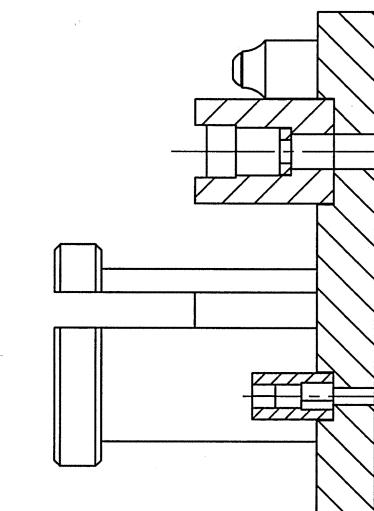
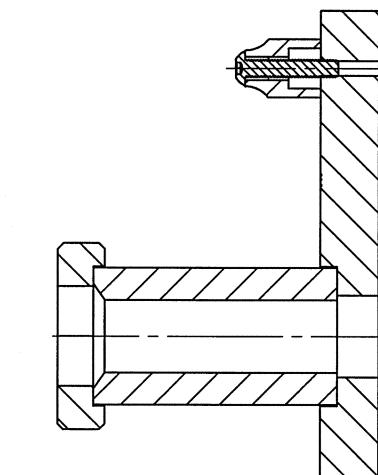
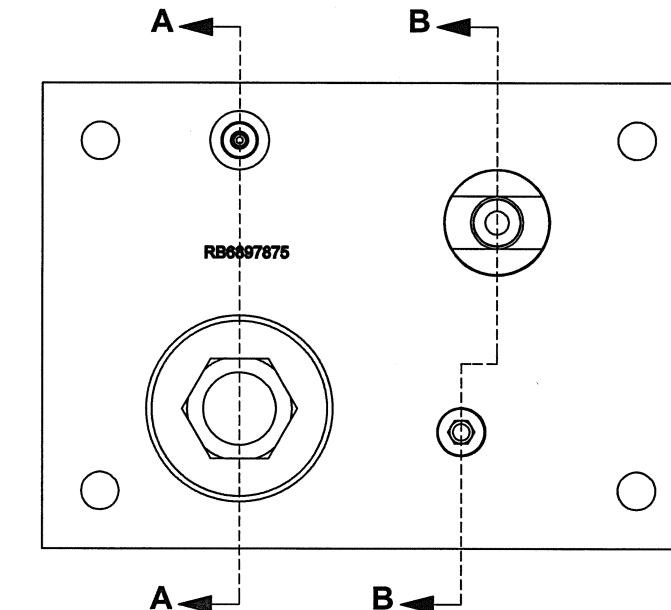
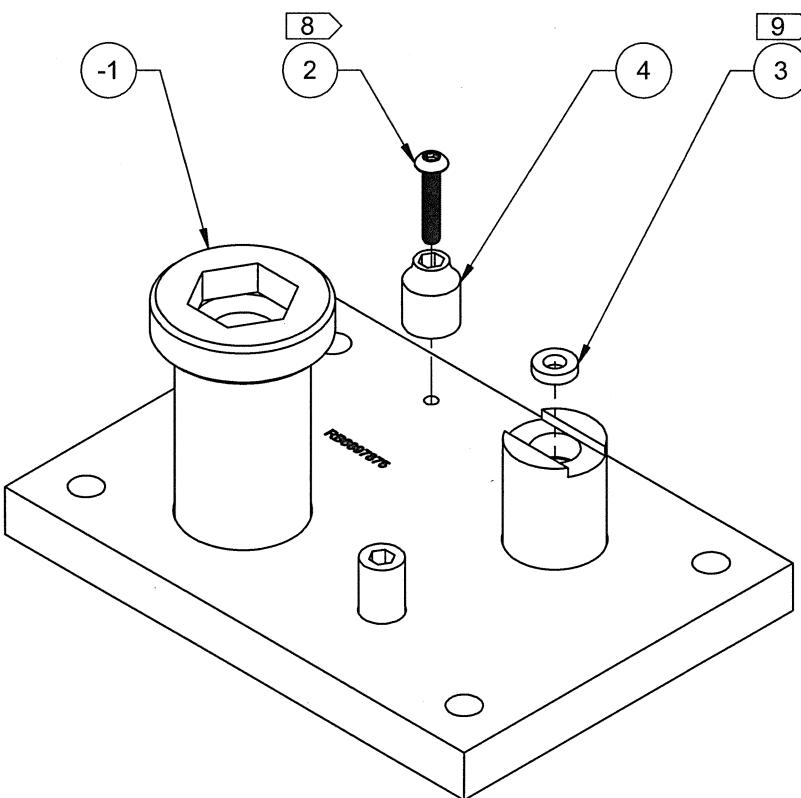


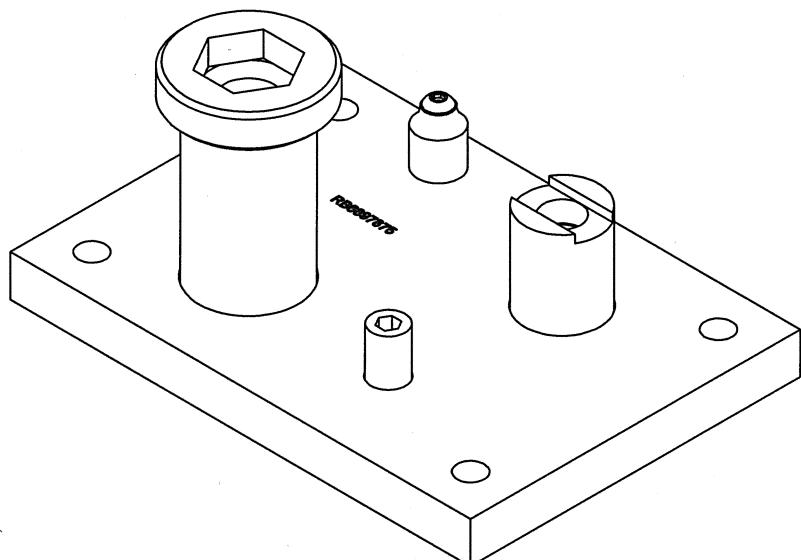
ITEM #	QTY	PART #	PART TITLE
-1	1	RB6897875-1	WELDMENT ASSY
2	1	McMaster#91255A273 OR EQUIV	BLACK OXIDE STEEL BUTTON HEAD HEX DRIVE SCREW #10-32 X 1" LG.
3	1	McMaster#90176A153 OR EQUIV	NYLON SPACER FOR 1/4" SCREW SIZE X 1/2" OD X 1/8" THK
4	1	MSC#48725303 OR EQUIV	6 POINTS STANDARD HAND SOCKET 1/4" X 3/8" DRIVE X 13/16" LG.

D



RB6897875 FUEL NOZZLE HOLDING FIXTURE

10



NOTES:

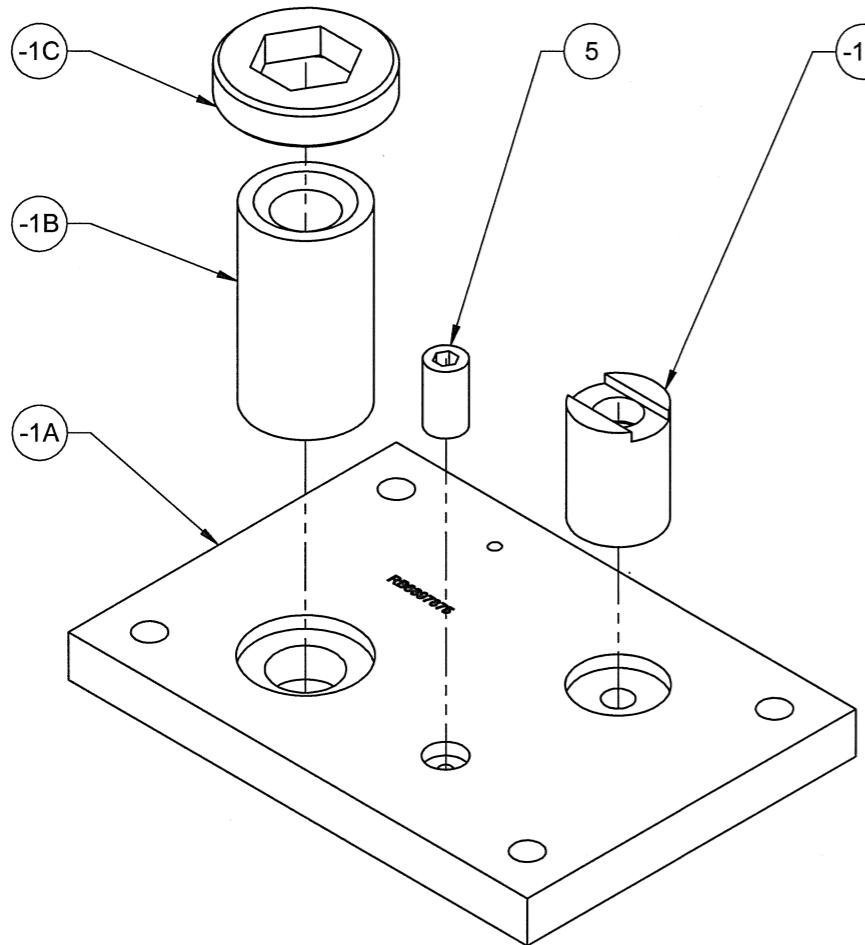
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 2 HAND TIGHT
- 9) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 3 WITH ITEM -1, AND REMOVE EXCESS
- 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

FOR OLDER REVs SEE PREVIOUS PDFs
TEMPLATE UPDATED PER DART HBY STANDARDS
ITEM -5 CHANGED FOR ITEM 3
ITEM -3 CHANGED FOR ITEM 5
ITEM -7 CHANGED FOR ITEM 2
ITEM -2 CHANGED FOR ITEM 4 PURCHASE PART
McMaster#90176A153
ITEM -1 WELD SYMBOL CORRECTED, ENGRAVE T/N, MADE IN USA & S/N REMOVED
ITEM -9 DOWEL PIN MCMaster-CARR #98381A172 REMOVED
ITEM -1A DIMENSION .1271/.1261 FOR DOWEL PIN REMOVED, MATERIAL A36/1018/1020 HR CHANGED FOR 4140 (28-32 Rc), HOLES DIMENSIONS CHANGED FOR LOOSER TOLERANCES, ENGRAVING T/N ADDED
ITEM -1B DIMENSION 1.500/1.496 CHANGED FOR 1.47, DIMENSION 2.620 CHANGED FOR 2.62
ITEM -1C DIMENSION 2.00 +/-0.03 CHANGED FOR 2.00, DIMENSION 1.514/1.508 CHANGED FOR 1.50, MATERIAL 4140/4142 RC 28-32 CHANGED FOR O1 48-52 Rc
ITEM -1D HOLES DIMENSIONS CHANGED FOR LOOSER TOLERANCES, DIMENSION 1.125/1.121 CHANGED FOR 1.120, DOWEL PIN HOLE REMOVED, DIMENSION .310 CHANGED FOR 0.375 + 0.005/-0, DIMENSION .5150/.5143 CHANGED FOR 0.5100, MATERIAL 4140/4142 RC 28-32 CHANGED FOR O1 48-52 Rc

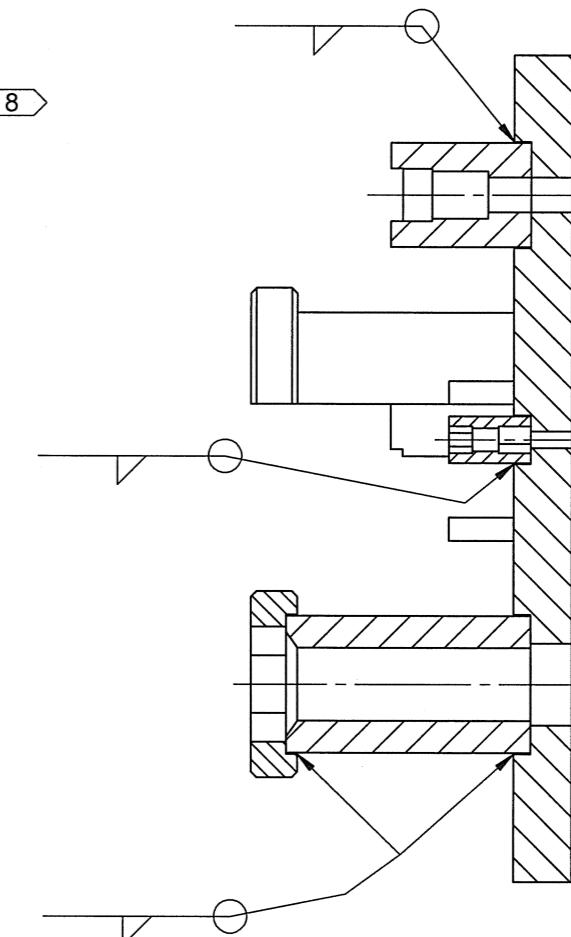
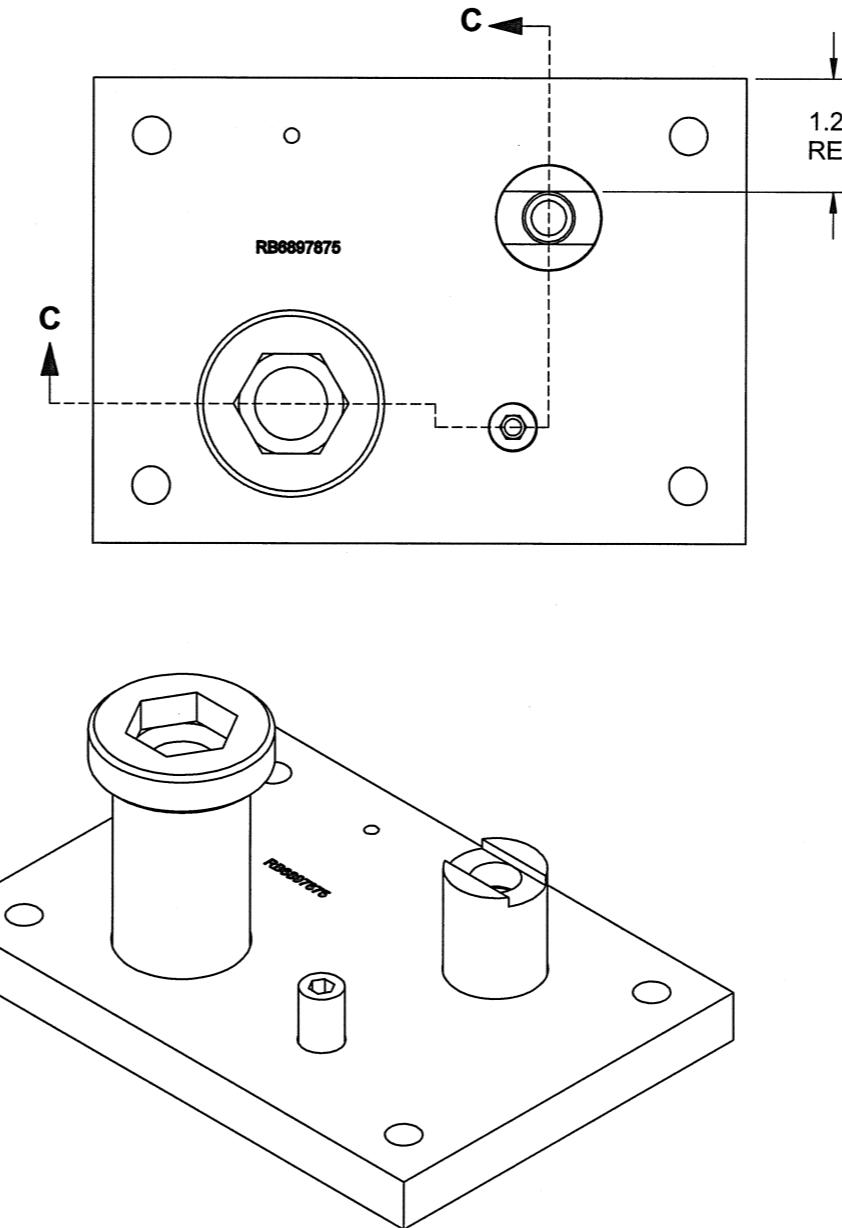
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
DRAWN	VM		
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED	W		
TOOL PART #	RB6897875		
TITLE	FUEL NOZZLE HOLDING FIXTURE		
DATE	2019-05-24		

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ITEM #	QTY	PART #	PART TITLE
-1A	1	RB6897875-1A	BASE
-1B	1	RB6897875-1B	RISER 1
-1C	1	RB6897875-1C	TOP
-1D	1	RB6897875-1D	RISER 2
5	1	SNAP-ON#IMTM8A OR EQUIV	1/4" DRIVE 6 POINT SAE 1/4" FLANK DRIVE, SHALLOW IMPACT SOCKET



RB6897875-1 WELDMENT ASSY

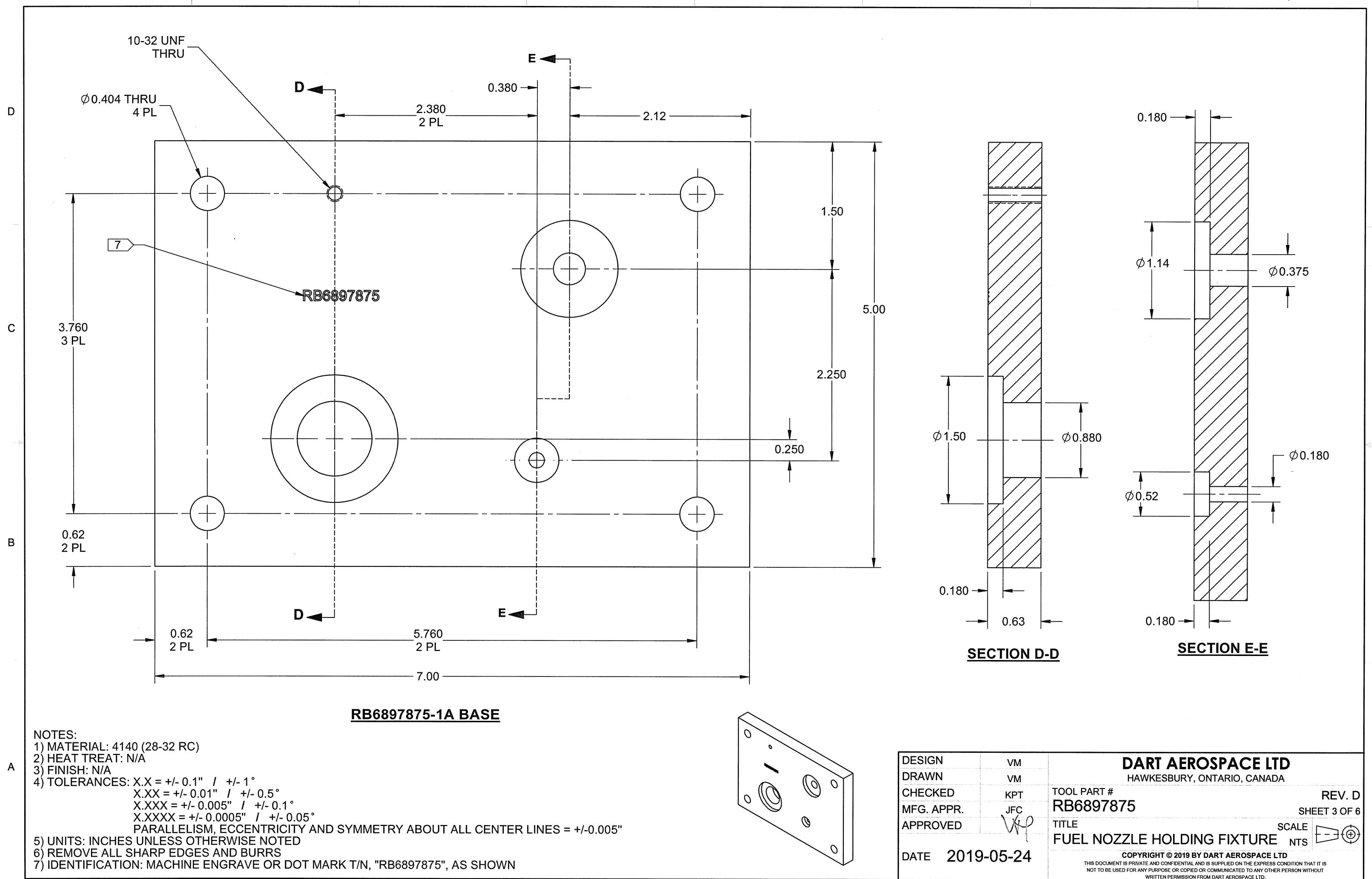


SECTION C-C

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) ALIGN PARALLEL TO LONG EDGE OF ITEM -1A
- 9) REMOVE WELD SPATTERS

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. D	
MFG. APPR.	JFC	SHEET 2 OF 6	
APPROVED	<i>[Signature]</i>	TOOL PART #	
		RB6897875	
DATE 2019-05-24		TITLE	
		SCALE NTS	
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NOTES:

1) MATERIAL: 4140 (2)
2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.05°

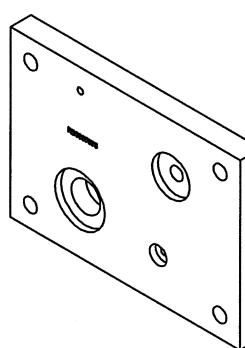
X.XXX = +/- 0.005" / +/- 0.1°

PARALLELISM, ECCENTRICITY, AND THE LUMINESCENTS

5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS

6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N. "PPC6807875" AS SHOWN

6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N. "RB6897875" AS SHOWN



DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	JFC
APPROVED	

DATE 2019-05-24

DART AEROSPACE LTD

HAWKESBURY ONTARIO CANADA

REF. D

REV'D
SHEET 3 OF 6

SHEET 3 OF 6

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For more information on the study, visit www.sciencedirect.com/science/article/pii/S0898268313000010.

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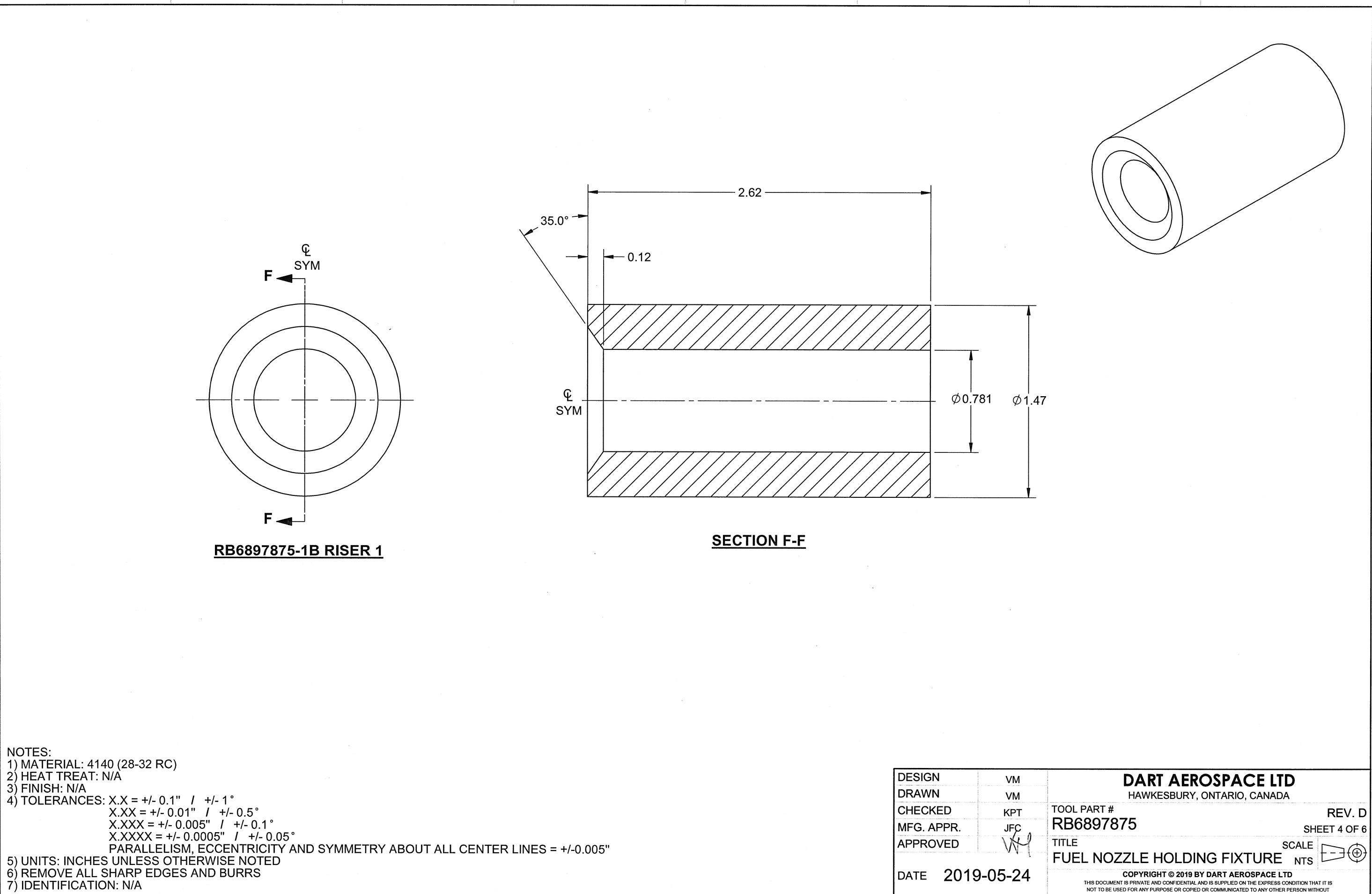
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B

B

A

A



NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1" / +/- 1^\circ$
 $X.XX = +/- 0.01" / +/- 0.5^\circ$
 $X.XXX = +/- 0.005" / +/- 0.1^\circ$
 $X.XXXX = +/- 0.0005" / +/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/-0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED	<i>[Signature]</i>		

DATE 2019-05-24

TOOL PART # **RB6897875**

REV. D

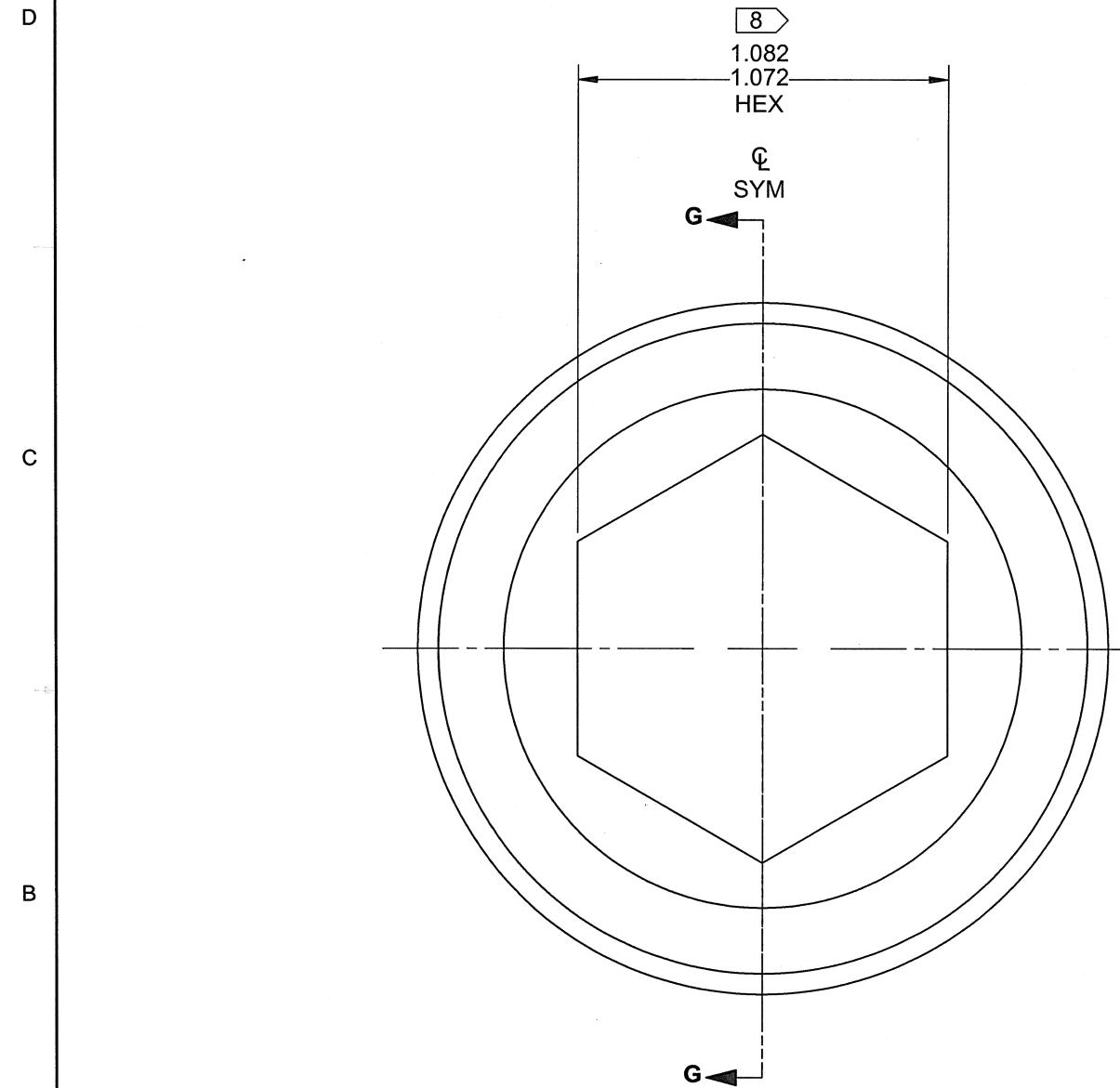
SHEET 4 OF 6

SCALE NTS

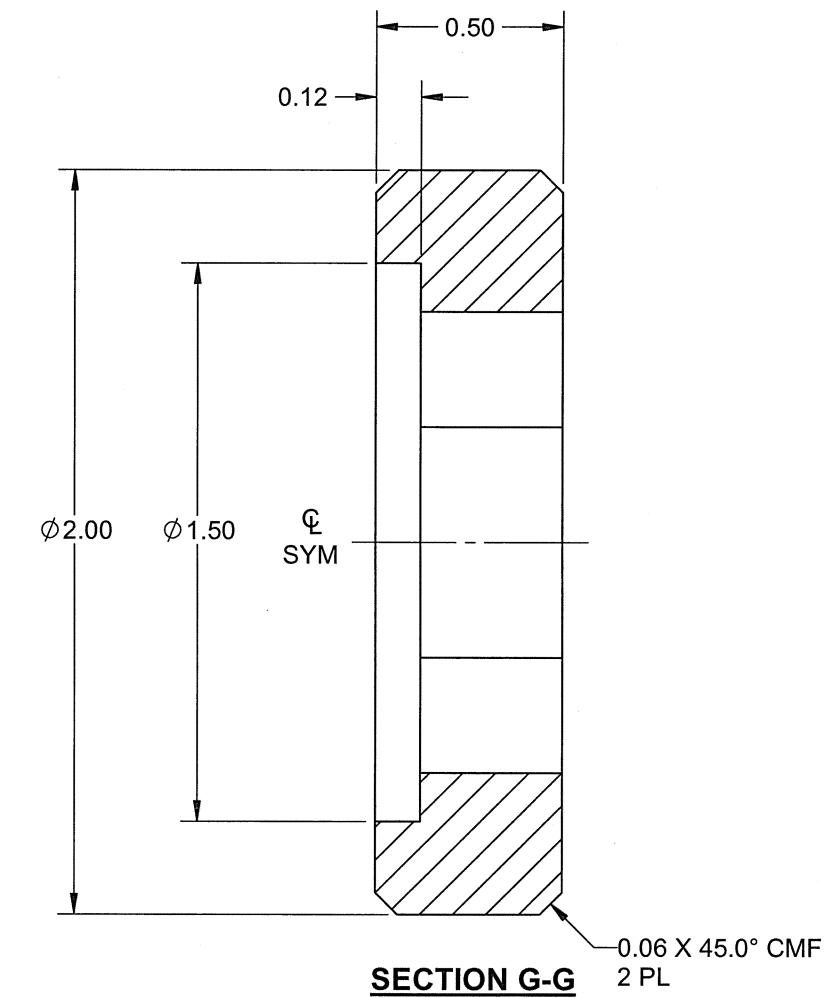
FUEL NOZZLE HOLDING FIXTURE

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RB6897875-1C TOP



NOTES:

- 1) MATERIAL: O1
- 2) HEAT TREAT: 48-52 Rc
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1" / +/- 1^\circ$
 $X.XX = +/- 0.01" / +/- 0.5^\circ$
 $X.XXX = +/- 0.005" / +/- 0.1^\circ$
 $X.XXXX = +/- 0.0005" / +/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. D	
MFG. APPR.	JFC	SHEET 5 OF 6	
APPROVED	<i>WJ</i>	TOOL PART #	
		RB6897875	
DATE 2019-05-24		TITLE	
		SCALE NTS	
FUEL NOZZLE HOLDING FIXTURE			

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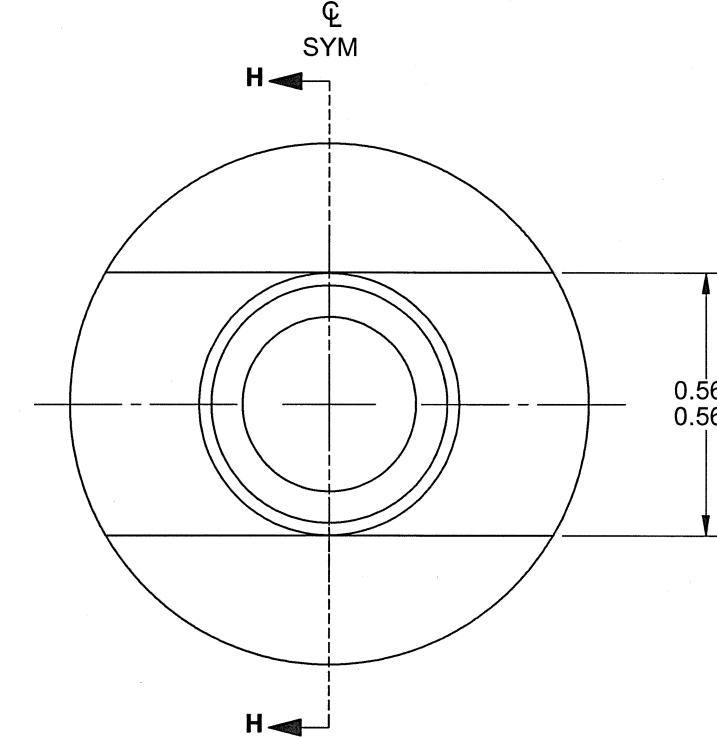
C

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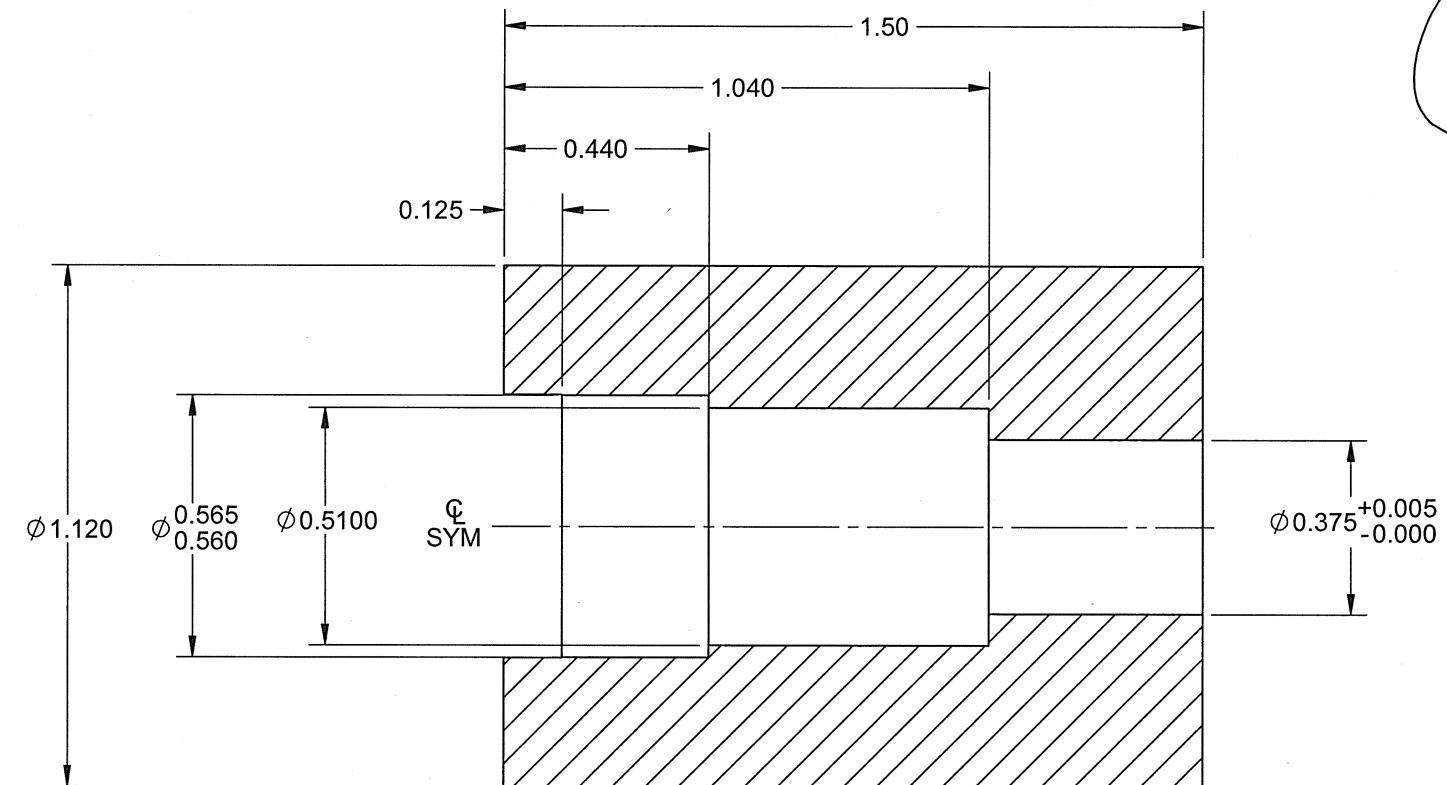
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A

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RB6897875-1D RISER 2



SECTION H-H

NOTES:

- 1) MATERIAL: O1
- 2) HEAT TREAT: 48-52 Rc
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	RB6897875	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	
DATE 2019-05-24		SCALE NTS	

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